Dart Aerospace Ltd.

41

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LONG STEP ASSEMBLY HIGH SKID RH
Job Number	: 34498		
Estimate Number	: 10274		
P.O. Number	: N/A	Part Number	: D350591312
This Issue	: 9/10/2007 S.O. No. : N/A	Drawing Number	: D3272 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 34331	Material	: N/A
Written By	:	Due Date	: 10/10/2007 Qty: 10 Um: Each
Checked & Approved By	: KJ 07.09.11		
Comment	: Est Rev:A 04.03.22 New issue KJ/RF Est Rev:B 07-06-09 Added D3572-1 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :	
1.0	DC	DOCUMENT CONTROL	(19) KJ 07.09.14
	Comment: DOCUMENT CONTROL Photocopy bluefile and type labels as per PPP D350-591-312 CHG001		SO 07/09/26
2.0	D32721	STEP	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) STEP BATCH: B 34005		PE 07-09-11 10
3.0	D30671	End Plate	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3067-1 End Plate B 32836 = 6 B 34312 = 4		PE 07.09.11 10
4.0	D32191	Support	
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) Pick: Qty Part Number Description Batch 2 D3219-1 Support B 34332		PE 07.09.11 10

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\fFORMS\Quality Assurance\approved QA\NCRWO RevD

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel end for welding FWD ONLY — 07.09.11 10

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 — 07.09.12 10
A/R Aluminum Rod M103794 M104721

3-Grind End Plate flush — a.m 07.09.13 10

Seq. #:	Machine Or Operation:	Description :
6.0	QC9	VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION — 07/09/14 (10)

Seq. #:	Machine Or Operation:	Description :
7.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP — 07/09/14 (x10RH)

Seq. #:	Machine Or Operation:	Description :
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1 — a.m 07.09.17 10

Seq. #:	Machine Or Operation:	Description :
9.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION — (10X) 07/09/19

Seq. #:	Machine Or Operation:	Description :
10.0	D3065041	Step Leg Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D3065-041	Step Leg Assy	B33510

a.m 07.09.19 10

Seq. #:	Machine Or Operation:	Description :
11.0	D30661	Spacer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
2	D3066-1	Spacer	B33857

a.m 07.09.19 10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
12.0	MS20600AD4W4	Rivets

Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)
Pick:
Qty Part Number Description Batch
16 MS20600AD4W4 Rivet M105408 a.m 07.09.19 10

13.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1
Assemble Leg Assembly as per Dwg D3272. a.m 07.09.19 10

14.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP 07/09/20 x(10 RH)

15.0	D30671	End Plate

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3067-1 End Plate 33432
07-09-20 10

16.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Bevel Aft end for welding 07.09.20 10

2-Inspect for foreign object as per QSI 024 07-09-20 10

3-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/R Aluminum Rod M103794 07-09-20 10

4-Grind End Plate flush a.m 07.09.21 (10)

5-Install last rivet. a.m 07.09.21 (10)

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
17.0	QC9	VISUAL WELDING INSPECTION
	Comment: VISUAL WELDING INSPECTION	07/09/21 (10)
18.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	09.21 (10) RH
19.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Touch up Alodine	09-09-21 (10)
20.0	POWDER COATING	POWDER COATING M105068 (10X)
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	
21.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 M105386
	Comment: HAND FINISHING RESOURCE #1 Wing Walk as per Dwg D3272 and QSI 005 4.4	FL 07/09/24 (10)
22.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: Inspect Powder Coat and Wing Walk	7/9/25 SQ
23.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
24.0	D22303	Mounting Lug
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Packing Kit Qty Part Number Description Batch 4 D2230-3 Mounting Lug B30993	7/9/25 SQ (X10)

Form: process

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** __________________ **NCR:** Yes No **DQA:** _____ **Date:** __________

QA: N/C Closed: _____ **Date:** __________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498 **Part Number:** D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
25.0	D2618	Bushing

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2618 Bushing 31831

Seq. #:	Machine Or Operation:	Description :
26.0	D2856400	Abrasion Strip

Comment: Qty.: 0.6000 f(s)/Unit Total : 6.0000 f(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D2856-400-720 Abrasion Strip 334293

Seq. #:	Machine Or Operation:	Description :
27.0	D32351	Mounting Lug

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 D3235-1 Mounting Lug 39996

Seq. #:	Machine Or Operation:	Description :
28.0	D3278041	Support Assembly

Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
1 D3278-041 Support Assembly 334006

Seq. #:	Machine Or Operation:	Description :
29.0	AN335A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s) (16)
Pick: Packing Kit
Qty Part Number Description Batch
2 AN3-35A Bolt M104021 4 M105408

Seq. #:	Machine Or Operation:	Description :
30.0	AN413A	Bolt

Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 AN4-13A Bolt M105426 7/9/28

Dart Aerospace Ltd

W/O:	WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

QA: N/C Closed: _____ **Date:** ________

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services
Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498
Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
31.0	AN536A	Bolt

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch 3 17 SØ
2 AN5-36A Bolt M105057 M105516

32.0	AN960JD10	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch SØ
F1 4 AN960JD10 Washer M105442

33.0	AN960JD416	Washer

Comment: Qty.: 16.0000 Each(s)/Unit Total : 160.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch SØ
F1 16 AN960JD416 Washer M104746

34.0	AN960JD516	Washer

Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch SØ
4 AN960JD516 Washer M104158

35.0	MS21042L3	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
F1 2 MS21042L3 Nut (or -3) M104936 7/9/25 SØ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes ~~No~~ (circled: No) **DQA:** LD **Date:** 07/09/25

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Monday, 9/10/2007 1:30:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LONG STEP ASSEMBLY HIGH SKID RH

Job Number: 34498

Part Number: D350591312

Job Number:

Seq. #:	Machine Or Operation:	Description :
36.0	MS21042L4	Nut

Comment: Qty.: 8.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
8 MS21042L4 Nut (or -4) M104683 SQ

37.0	MS21042L5	Nut

Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)
Pick: Packing Kit
Qty Part Number Description Batch
2 MS21042L5 Nut (or -5) M104547 (8) M104812 (12) 7/9/25 SQ

38.0	QC4	INSPECT 100% KITS FOR COMPLETENESS

Comment: INSPECT 100% KITS FOR COMPLETENESS 07/09/26

39.0	PACKAGING 1	PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D350-591-312
Location: 13 7/9/26 SQ (10X)

40.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE 07/09/26

Job Completion 07.09.26

Form: process

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 — REV. B — SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG — SCALE NTS

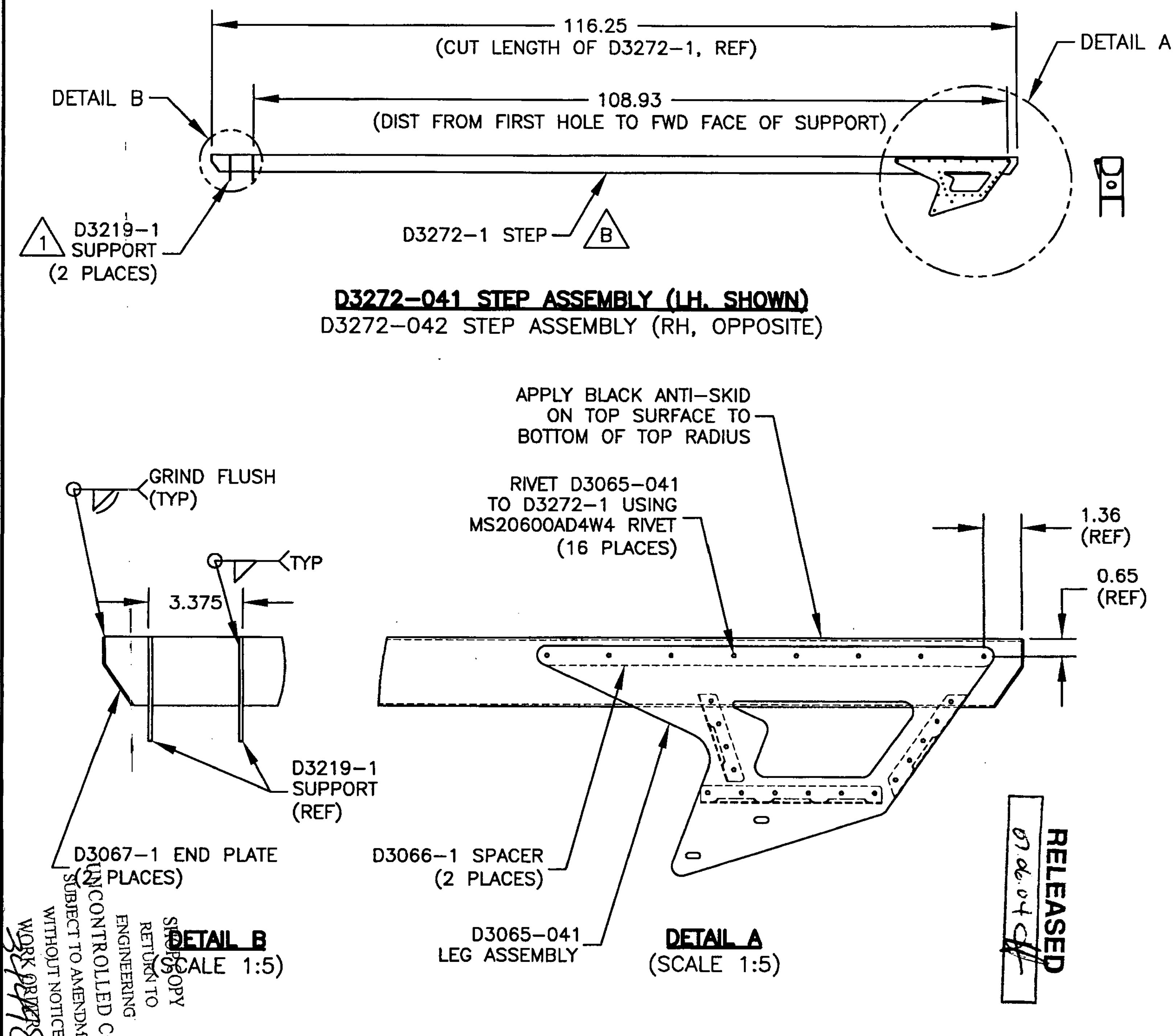
A	04.03.01	NEW ISSUE
B	07.05.18	D3272-1 WAS D2622-120

RELEASED
07.06.04

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		**D3272-041**	**STEP ASSEMBLY, HIGH LONG (LH)**
	X	**D3272-042**	**STEP ASSEMBLY, HIGH LONG (RH)**
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1 (B)	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
2) WELD PER DART QSI 004
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
   POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
   BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.



DART

DESIGN	DRAWN BY
CHECKED	APPROVED
DATE 07.05.18	

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3272 — REV. B — SHEET 2 OF 3

TITLE: STEP ASSEMBLY, HI LONG — SCALE 1:20

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3272 — REV. B — SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG — SCALE 1:20

RELEASED 07.06.04

